

WHAT IS CLAIMED IS:

1 1. A method of producing composite vehicle door panels
2 comprising:

3 manufacturing a skin in a vacuum-forming mold;
4 transferring the skin to a RIM mold;
5 applying natural fiber and an isocyanate and resin mixture onto the
6 skin;
7 polymerizing the isocyanate and resin mixture, natural fiber, and a
8 skin into a composite vehicle door panel.

1 2. The method of claim 1 wherein the natural fibers are hemp,
2 kenaf, sisal, flax, or jute.

1 3. The method of claim 1 further comprising the step of
2 trimming the skin before natural fibers are placed on the skin.

1 4. The method of claim 1 further comprising the step of
2 trimming the skin after the isocyanate and resin mixture, natural fiber, and the skin
3 have polymerized.

1 5. The method of claim 1 wherein the natural fibers are provided
2 as rovings.

1 6. The method of claim 1 wherein the natural fibers are provided
2 as a mat.

1 7. The method of claim 1 wherein the natural fibers and
2 isocyanate and resin mixture are applied to the skin simultaneously.

1 8. The method of claim 1 wherein the natural fibers are applied
2 to the skin first and the isocyanate and resin mixture are applied onto the natural
3 fibers.